

File: Friday, 18/07/2008 10:52:38 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKI
 Job Number : 40628
 Estimate Number : 13478
 P.O. Number :
 This Issue : 18/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37953
 First Issue : 11 Type : R&D MACHINED PARTS Drawing Number : D3795 PREL
 Previous Run : Project Number : N/A
 Written By : 18/07-18 Drawing Revision : PREL
 Checked & Approved By : Material :
 Comment : Est Rev:A New Issue 08-07-18 JLM Verified By:DD Due Date : 25/07/2008 Qty: 3 Um: Each

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. # Machine Or Operation: Description :

1.0 MUHMMWB10 UHMW 1" Black



Comment: Qty.: 2.7930 sf(s)/Unit Total: 8.3790 sf(s)

UHMW 1" Black

Batch: 108762

RB 8-7-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg File d3795-3 Blank

RB 8-7-22

(3)

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA732 Rev: AA & Dwg D3795 Rev: A

2-Deburr per dwg D3795

M.A 08/07/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/07/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

18/06-07-31

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKI

Job Number: 40628

Part Number: D37953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



ENGINEERING APPROVAL

Comment: PACKAGING RESOURCE #1

Identify and Stock

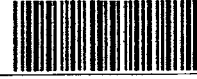
Location:

B108645
Not For Stock!
08.07.29

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-06

Change to w/o 00245

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

For B108645
{ LENGTH IS 47.50" WSTEAD OF 48.00"
ACCEPTABLE FOR DART'S
FIT & FUNCTION PURPOSES
ONLY!
08.07.29

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

B108762

08.09.09

S.V.P.

Met en stock.
+

Location.

Après donner la w/o
à Jason. 😊

DART AEROSPACE LTD	Work Order: 40628
Description: SK1	Part Number: D3795-3
Inspection Dwg: D3795 Rev: A	Page 1 of 12

FIRST ARTICLE INSPECTION CHECKLIST

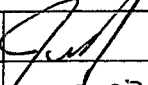



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R 0.13	+/- .030	R 0.13	✓			
6.62	+/- .030	6.620	✓			
5.810	+/- .010	5.816	✓			
0.810	+/- .010	0.812	✓			
Ø 0.261	+0.005 / - .001	Ø 0.260	✓			
Ø 0.93 x Ø 30 DP	+/- .030	Ø 0.929 x 32 DP	✓			
1.000	+/- .010	.996	✓			
8.667	+/- .010	8.667	✓			
16.333	+/- .010	16.333	✓			
24.000	+/- .010	24.000	✓			
31.667	+/- .010	31.667	✓			
39.333	+/- .010	39.333	✓			
47.000	+/- .010	47.000	✓			
48.00	+/- .030	48.00	✓			
0.95	+0.030 / - 0.010	0.962	✓			
0.20	+0.030 / - 0.010	0.198	✓			
3.40	+/- .030	3.392	✓			
R 0.25	+/- .030	R 0.25	✓			
R 2.64	+/- .030	R 2.64	✓			
0.050 x 45°	+/- .010	0.047 x 45°	✓			
0.19 x 45°	+/- .030	0.193 x 45°	✓			
0.38	+0.030 / - 0.010	0.344	✓			
0.063 x 45°	+/- .010 / ± 1/2°	0.053 x 45°	✓			

Measured by: M.A	Audited by: 	Prototype Approval: 
Date: 08/07/30	Date: 08-07-31	Date: 08-08-01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

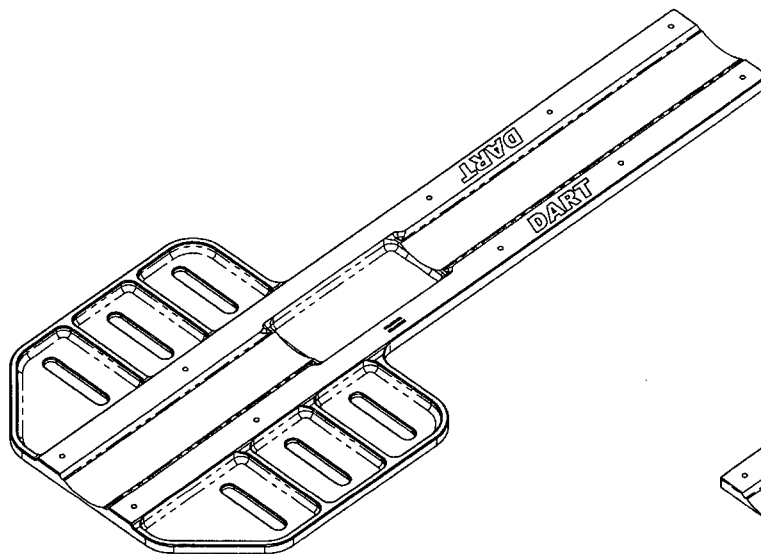
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.07.22	1.0	Three PARTS SCRAP BECAUSE of BLANKS Too short B.108645	<i>[Signature]</i>	08.08.05			

Part No: D 3795-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

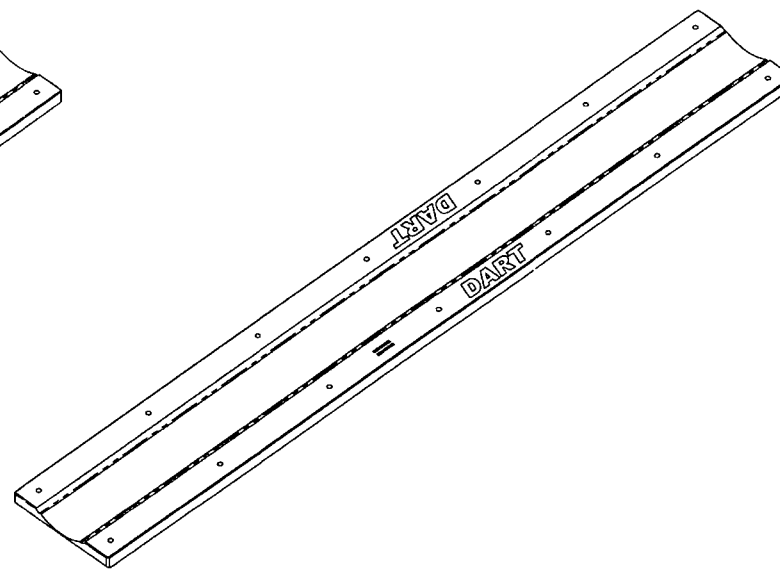
QA: N/C Closed: _____ Date: _____

NCR: 40628		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Plank Blanks too short R.C Blanks were ordered too small	<i>[Signature]</i> 08.08.10	Scrap and Destroy and Replace Qty ③ B# 108645	<i>[Signature]</i> 8/08/05	S 8/08/05	<i>[Signature]</i> 08.08.10	S 08/08/05

NOTE: Date & initial all entries



D3795-1 412 SKI - FWD SECTION



D3795-3 412 SKI - MID SECTION

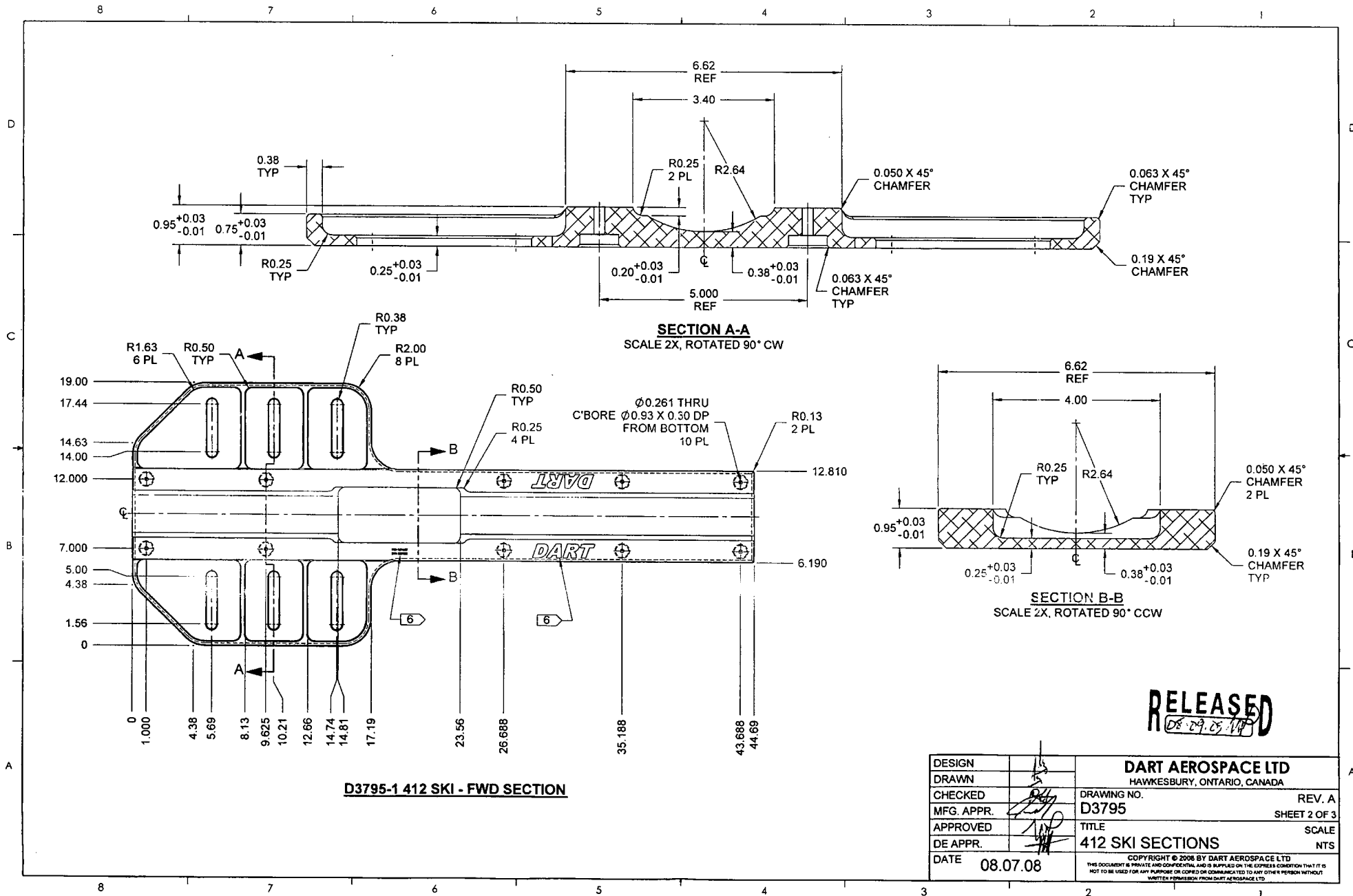
RELEASED
08-07-08

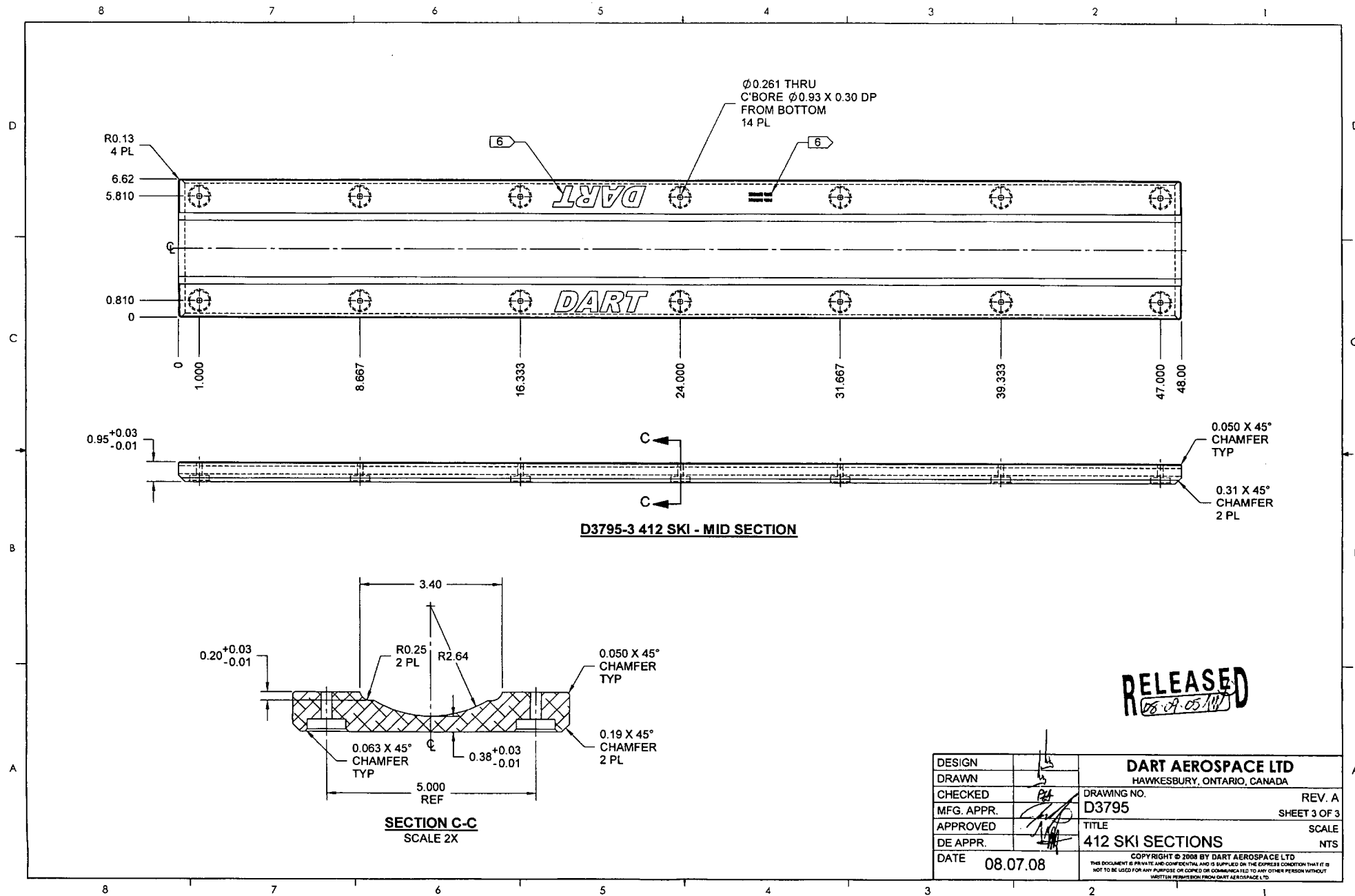
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: - ENGRAVE WITH DART P/N "D3795-X" AND B/N "BXXXXX" USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010
- ENGRAVE WITH DART LOGO USING 1.00 HIGH LETTERS TO MAX DEPTH OF 0.012
- 7) WEIGHT: D3795-1 = 9.37 lbs
D3795-3 = 7.87 lbs

A	NEW ISSUE	MB	08.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.08		

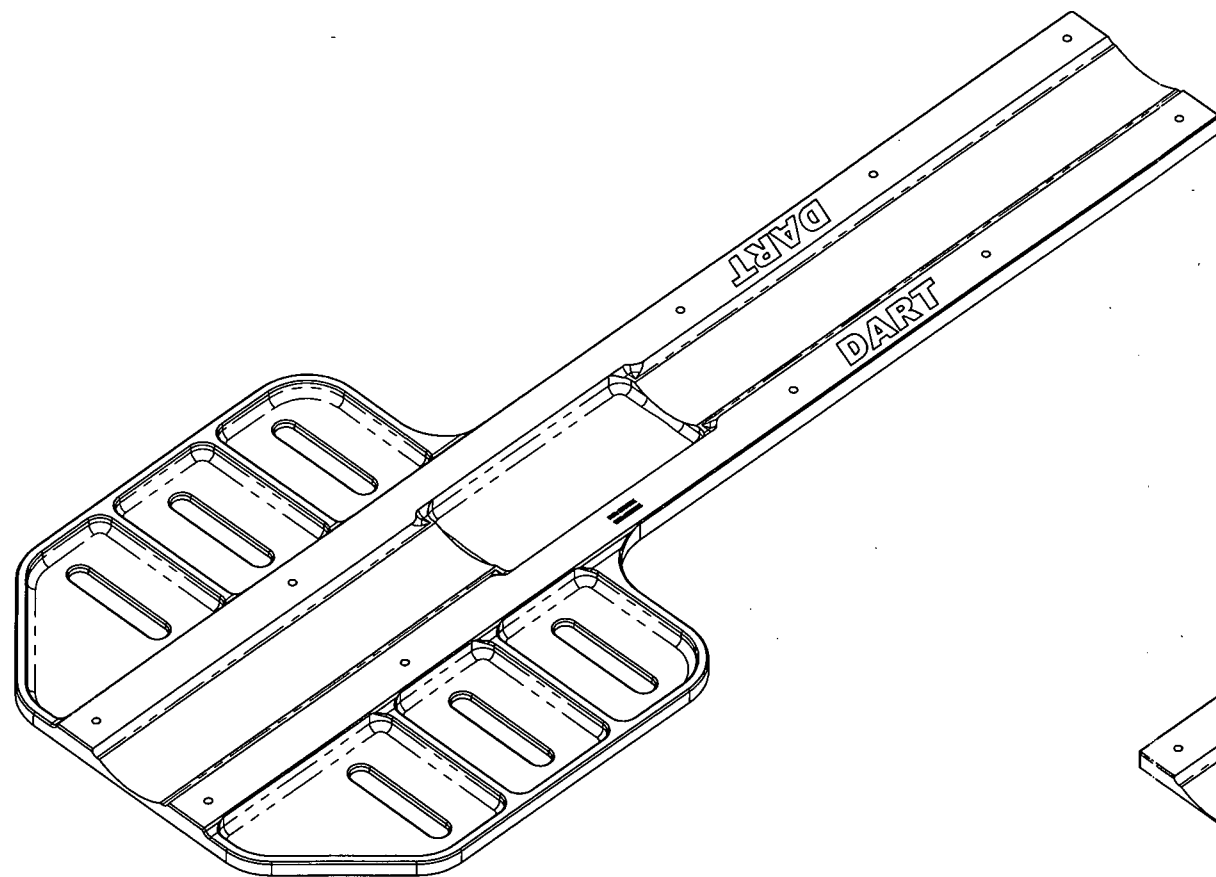
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3795	REV. A
TITLE 412 SKI SECTIONS	SCALE NTS
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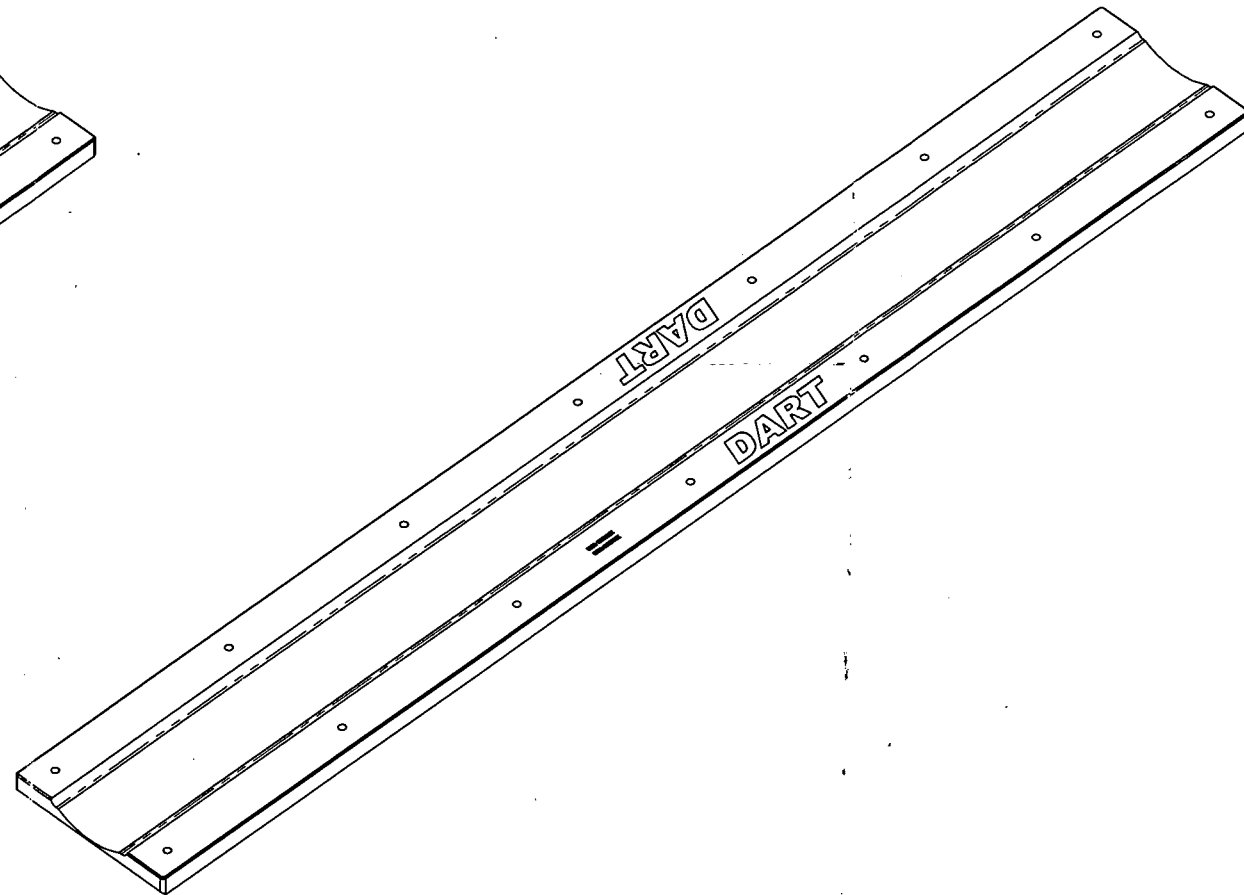


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08.05.11

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
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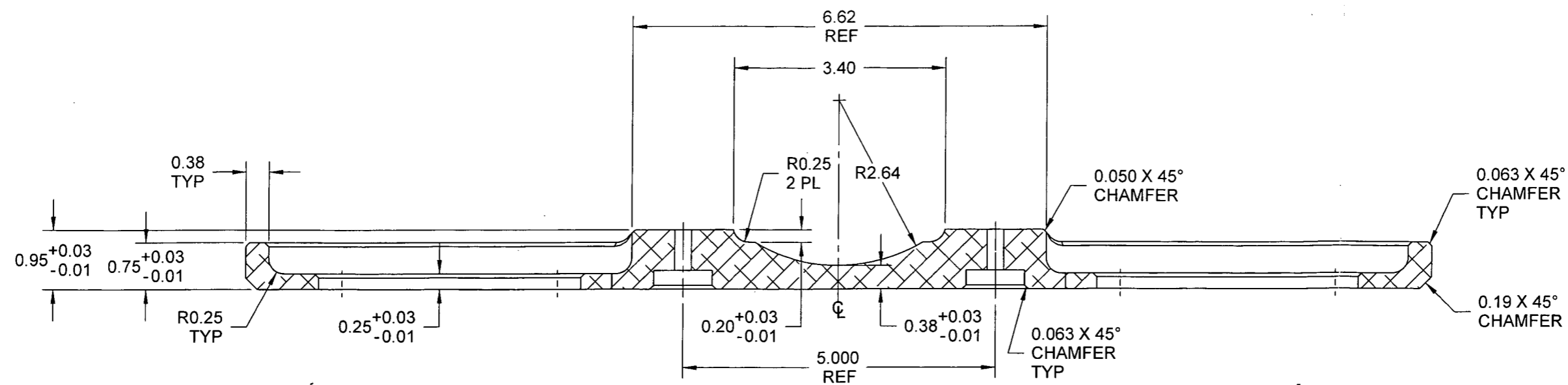


D3795-3 412 SKI - MID SECTION

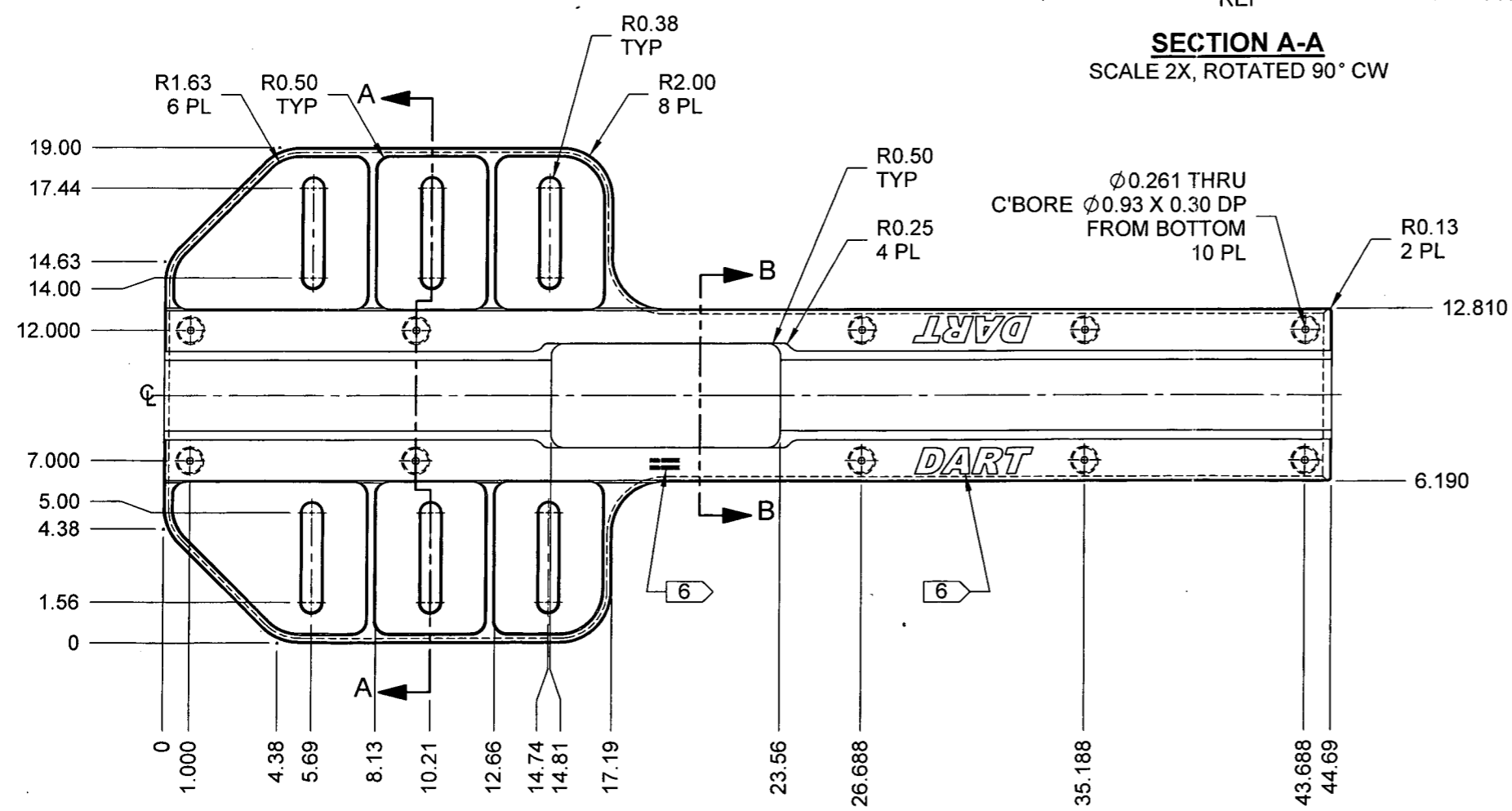
PRELIMINARY ISSUE
308.07.15

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REF DART SPEC MUHMBW
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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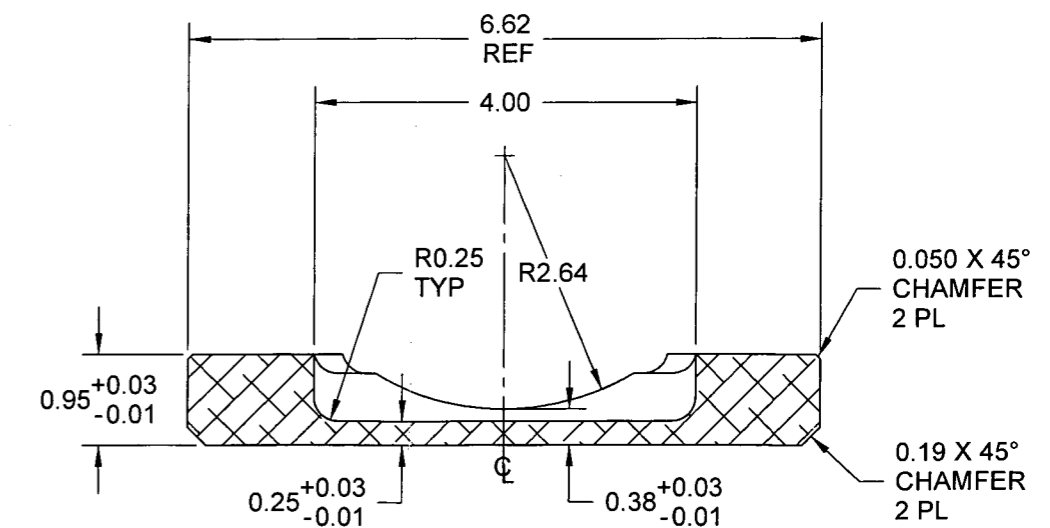
A	NEW ISSUE		MB	08.07.08
REV.	DESCRIPTION		BY	DATE
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SECTION A-A
SCALE 2X, ROTATED 90° CW



D3795-1 412 SKI - FWD SECTION



SECTION B-B
SCALE 2X, ROTATED 90° CCW

PRELIMINARY ISSUE
15 08.07.15

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